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D350-636-013
Job Sheet 203446



Part No: D350-636-013

Job Qty: 1 pcs

Part Name: Skidtube LH, Std Wearplates, DART (Apical) Tri-Bag/Air Cruisers Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/19/19

Job Tracking No:

Due Date: 12/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2750-043 REV.H IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-594 DD VERF:JLM IPP REV:S 18.11.12 AS PER DWG REV.H DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs			0.00	4.62	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		TF
							Skidtubes - 5		BE
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs			0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
							QC 10 - 68		
130	QC 5	1 pcs			0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
140 Handfinish - 1-1 Chemical- B4B 1 pcs	0.00 0.97		Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	★ NOV 28 2019
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
150 QC 7 1 pcs	0.00 0.00		QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	MLG
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	

160 Skidtubes - 2 - B4B	1 pcs	0.00 4.62	QC 7 - 79	
			Skidtubes - 1 - B4B	
			Skidtubes - 2 - B4B	
			Skidtubes - 3 - B4B	MGA
			Skidtubes - 4 - B4B	TF
			Skidtubes - 5 - B4B	BE
			Skidtubes - 6 - B4B	
170 QC 10	1 pcs	0.00 0.00	Skidtubes - 7 - B4B	
			QC 10 - 10	
			QC 10 - 18	
			QC 10 - 24	
			QC 10 - 43	
			QC 10 - 50	
			QC 10 - 58	
180 QC 5	1 pcs	0.00 0.00	QC 10 - 9	DAS
			QC 10 - 68	DEC 10 2019 68
			QC 5 - 10	9-89
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	0.00 0.33	QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	DAS
200 Spray Paint - 2 - B4B	1 pcs	0.00 0.37	QC 5 - 68	DEC 10 2019 68
			QC 5 - 9	9-89
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
204 QC 14	1 pcs	0.00 0.00	Handfinish - 2 - 1 - B4B	
			Handfinish - 2 - 2 - B4B	DEC 10 2019
			Handfinish - 2 - 3 - B4B	
			Handfinish - 2 - 4 - B4B	DAS
			Spray Paint - 1 - B4B	47 DEC 11 2019
			Spray Paint - 2 - B4B	9-89
			Spray Paint - 3 - B4B	
230 Handfinish - 4-1-Assembly-B4B	1 pcs	0.00 0.97	Spray Paint - 4 - B4B	
			QC 14 - 15	
			QC 14 - 2	
			QC 14 - 34	
			QC 14 - 41	
			QC 14 - 51	
			QC 14 - 58	
			QC 14 - 59	
			QC 14 - 9	
			QC 14 - 68	DAS
			QC 14 - 40	DEC 11 2019 40
			QC 14 - 19	9-89
			QC 14 - 43	
			QC 14 - 24	
			QC 14 - 61	
			QC 14 - 81	
230 Handfinish - 4-1-Assembly-B4B	1 pcs	0.00 0.97	Handfinish - 4 - 1 - B4B	47 12-12-19

			Handfinish - 4 - 10 - B4B	
			Handfinish - 4 - 11 - B4B	
			Handfinish - 4 - 12 - B4B	
			Handfinish - 4 - 13 - B4B	
			Handfinish - 4 - 14 - B4B	
			Handfinish - 4 - 15 - B4B	
			Handfinish - 4 - 2 - B4B	
			Handfinish - 4 - 3 - B4B	
			Handfinish - 4 - 4 - B4B	
			Handfinish - 4 - 5 - B4B	
			Handfinish - 4 - 6 - B4B	
			Handfinish - 4 - 7 - B4B	
			Handfinish - 4 - 8 - B4B	
			Handfinish - 4 - 9 - B4B	
240 QC 5	1 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	0.00 0.00	Packaging 1 - 1 - B4B	
			Packaging 1 - 2 - B4B	
			Packaging 1 - 3 - B4B	
			Packaging 1 - 4 - B4B	
			Packaging 1 - 5 - B4B	
			Packaging 1 - 6 - B4B	
			Packaging 1 - 7 - B4B	
			Packaging 1 - 8 - B4B	
			Packaging 1 - 9 - B4B	
			Packaging 1 - 10 - B4B	
			Packaging 1 - 11 - B4B	
			Packaging 1 - 12 - B4B	
			Packaging 1 - 13 - B4B	
			Packaging 1 - 14 - B4B	
			Packaging 1 - 15 - B4B	
			Packaging 1 - 16 - B4B	
			Packaging 1 - 17 - B4B	
			Packaging 1 - 18 - B4B	
			Packaging 1 - 19 - B4B	
			Packaging 1 - 20 - B4B	
			Packaging 1 - 21 - B4B	
			Packaging 1 - 22 - B4B	
			Packaging 1 - 23 - B4B	
			Packaging 1 - 24 - B4B	
			Packaging 1 - 25 - B4B	
			Packaging 1 - 26 - B4B	

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			Packaging 1 - 27 - B4B	
			Packaging 1 - 28 - B4B	
			Packaging 1 - 29 - B4B	
			Packaging 1 - 30 - B4B	
			Packaging 1 - 31 - B4B	
			Packaging 1 - 32 - B4B	
			Packaging 1 - 33 - B4B	
			Packaging 1 - 34 - B4B	
			Packaging 1 - 35 - B4B	
			Packaging 1 - 36	
260 QC 4	1 pcs	0.00 0.00	QC 4 - 28	
			QC 4 - 58	
			QC 4 - 69	
			QC 4 - 9	
			QC 4 - 46	
			QC 4 - 68	
			QC 4 - 72	
			QC 4 - 74	
			QC 4 - 75	
			QC 4 - 78	
270 Packaging 3-1 - Stock - B4B	1 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	0.00 0.00	DC - 1 - B4B	
			DC - 2 - B4B	
280 QC 21 - FG	1 pcs	0.00 0.00	QC 21 - FG - 21	

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FG Back

QC 21 - FG - 70

QC 21 - SA - 53

Part Op 110 - (Skid tubes) 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT

Descriptions: end per dwg D2750-3 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750 sheet 4 (D2750-3 details). Drill using drill Jig DT8150 & DT8864A for second side only DT8864B for first side (detail B) 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail A to 0.297" (total of 2 holes per side) 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 139019 9- Grind welds flush as per Dwg D2750

120 - (QC10- Inspect visual per QSI004- ground welds)

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - QC7- Inspect Chemical Conversion Coat)

160 - (Skid tubes) 1- Open up holes using hole saw on section AW-AW 0.500" (4 per side) as per dwg D2750 2- Open holes using hole saw on section BC-BC 0.3125" (4 per side) 3- Open up holes using uni-bit of Detail T and ground handling to 0.625" (total of 8 holes per side Detail AV-AV) as per dwg D2750. 4- Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10) 5- Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required. 6- Bond web D2739 in place as per QSI 015, let cure for 12hrs. 7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 10) 8- Grind welds flush as per Dwg D2750 9- Spot face ground handling holes (total of 4 places per side) as per dwg D2750 10- Deburr holes, ensure tube is free of all scratches before sending to paint.

170 - QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***

190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5218188 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5231052

204 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024

230 - (Assemble as per dwg) 1- Install inserts as per dwg D2750 2- Inspect for Foreign Object 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 5231092 EXP DATE: 26-3-18 4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 5138843 5- Coat all exposed fasteners with "LPS Procyon" batch: 4132640

240 - (QC5- Inspect part completeness to step on W/O)

250 - (Pick Kit)

260 - QC4- 100% Inspect kits for completeness)

270 - (Identify as per dwg & Stock Location: _____) Package as per PPP D350-636-013

275 - (Document Control) Photocopy blue file and type labels per PPP D350-636-013 CHG 008

280 - (QC21- Final Inspection - Work Order Release)

Job BOM

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Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	110-Skidtubes - 1	5216547
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5192776
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	5231540
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5186298
D3490-5	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5210483
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5214460
AN3C5A	Bolt	34 Ea (34 ea)	230-Handfinish - 4-1-Assembly-B4B	5123445
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5217722
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5230838
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5221549
D2743	Crossbolt Spacer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5214194
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5219776
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5215682
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5218656
D3492-5	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5191167
D3537-1	Wearpad	3 pcs (3 ea)	230-Handfinish - 4-1-Assembly-B4B	522952
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5230504
D3791-1	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5219067
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5210630
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5219152
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5725322
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5215506-1
NAS1149C0332R	Washer (AN960C10L)	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5233302
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	50760173
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5214921
NAS1611-005	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5144425
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5217830
D3793-5	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5729912
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5184404
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5210551
D3493-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5225633
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5237859
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166718

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-LH	1	5	0
	D2744	1	14	0
	D2739	1	9	0
160-Skidtubes - 2 - B4B	D3490-1	4	246	0
	D3490-5	4	143	0
	ALS4-1032-225	38	882	0
230-Handfinish - 4-1-Assembly-B4B	AN3C5A	34	703	0
	AN3C6A	4	70	0
	AN6C44A	4	125	0
	AN8C35A	1	29	0
	D2743	8	451	0
	D2745	8	55	0
	D3488-3	1	17	0
	D3492-1	8	104	0
	D3492-5	8	300	0
	D3537-1	3	75	0
	D3631-1	8	944	0
	D3791-1	1	6	0
	D3793-1	1	23	0
	D3793-3	1	7	0
	D3793-5	1	14	0
	MS21043-6	4	291	0
	MS21083C8	1	66	0
	NAS1149C0332R	38	3,245	0
	NAS1149C0832R	1	236	0
	NAS1515H3L	4	131	0
	NAS1611-005	8	294	0
	NAS1611-010	8	160	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	69	0
	D2741	1	39	0
	D3493-1	2	38	0
	MS21083C8	2	66	0
	NAS1149D0863J	2	279	0

Part Specifications

Specifications could not be found.

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QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X					D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X				D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X			D2750-044	350 SKIDTUBE ASSEMBLY, RH
				X		D2750-051	350 SKIDTUBE ASSEMBLY, LH
					X	D2750-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1						D2750-1	350 SKIDTUBE ASSEMBLY
	1					D2750-2	350 SKIDTUBE ASSEMBLY
		1				D2750-3	350 SKIDTUBE ASSEMBLY
			1			D2750-4	350 SKIDTUBE ASSEMBLY
				1		D2750-5	350 SKIDTUBE ASSEMBLY
					1	D2750-6	350 SKIDTUBE ASSEMBLY
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG
8	8					D3492-043	PLUG
		8	8			D3492-045	PLUG
3	3	3	3	3	3	D3537-1	WEARPAD
8	8	8	8	8	8	D3631-1	WASHER
1	1	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	1	1	D3793-5	WEARSHOE
38	38	38	38	38	38	ALS4-1032-225	INSERT
				1	1	AN3C34A	BOLT
34	34	34	34	34	34	AN3C5A	BOLT
4	4	4	4	4	4	AN3C8A	BOLT
4	4	4	4	4	4	AN6C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
				1	1	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
38	38	38	38	38	38	NAS1149C0332R	WASHER
				2	2	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0632R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.1 lbs
D2750-051/-052 = 25.7 lbs
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 19/64" SIZE HOLES (ϕ 0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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H	ADDED -051/-052 (ZN DS-1 SHEETS 4, 15-16); ADDED D2750-041 (ZN C5-1 SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11/-12/-13/-14); D3793-5 REPLACES D3535-25 (ZN B6-1, C4-11/-12/-13/-14); NAS1149C0332R REPLACES AN860C10L (ZN A5-1, B1-11/-12/-13/-14, C7-11/-12/-13/-14); NAS1149C0632R REPLACES AN860C816L (ZN A5-1, C1-11/-12/-13/-14); REMOVED D3794-1/-3, AND D3536-25 GASKETS	ZF	18.03.05
G	CORRECTED TOLERANCE ON ϕ 0.500 THRU HOLE: IS +0.01/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4-5-6-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-278 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C6-1); WEARSHOE HOLES UNDER FWD/DAFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 06-043	PH	06.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN860C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24894-S263 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
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8 7 6 5 4 3 2 1

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C

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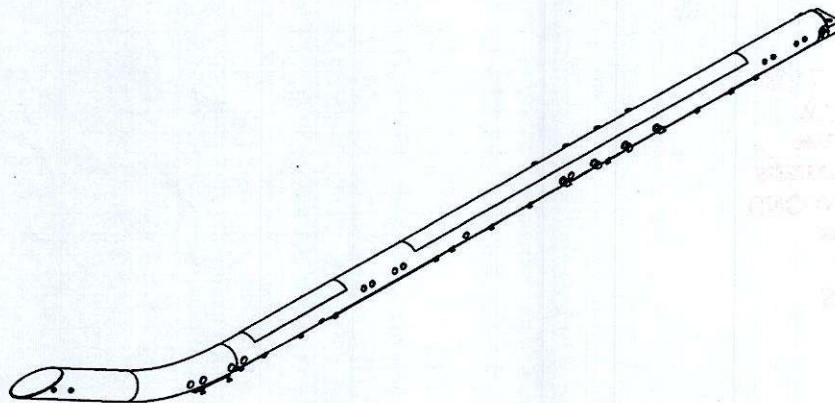
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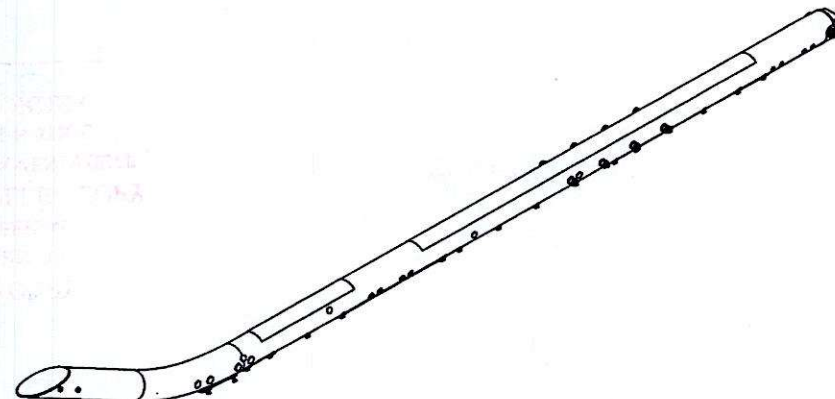
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A



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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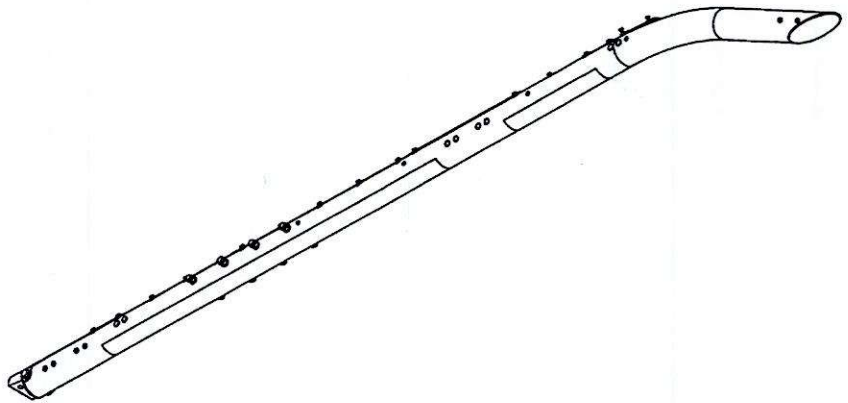
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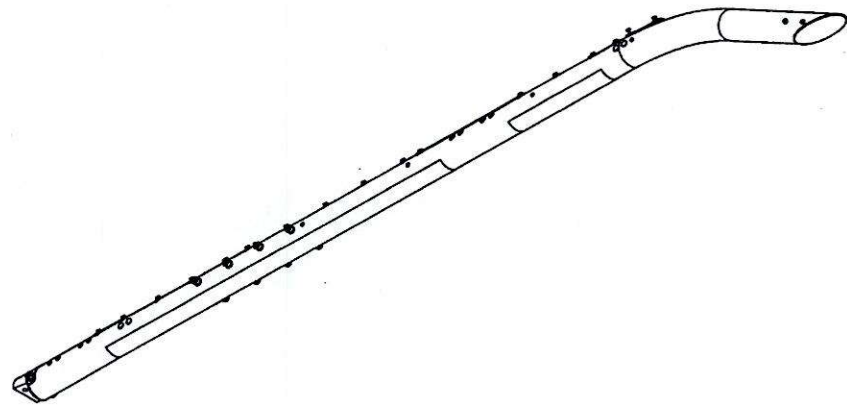
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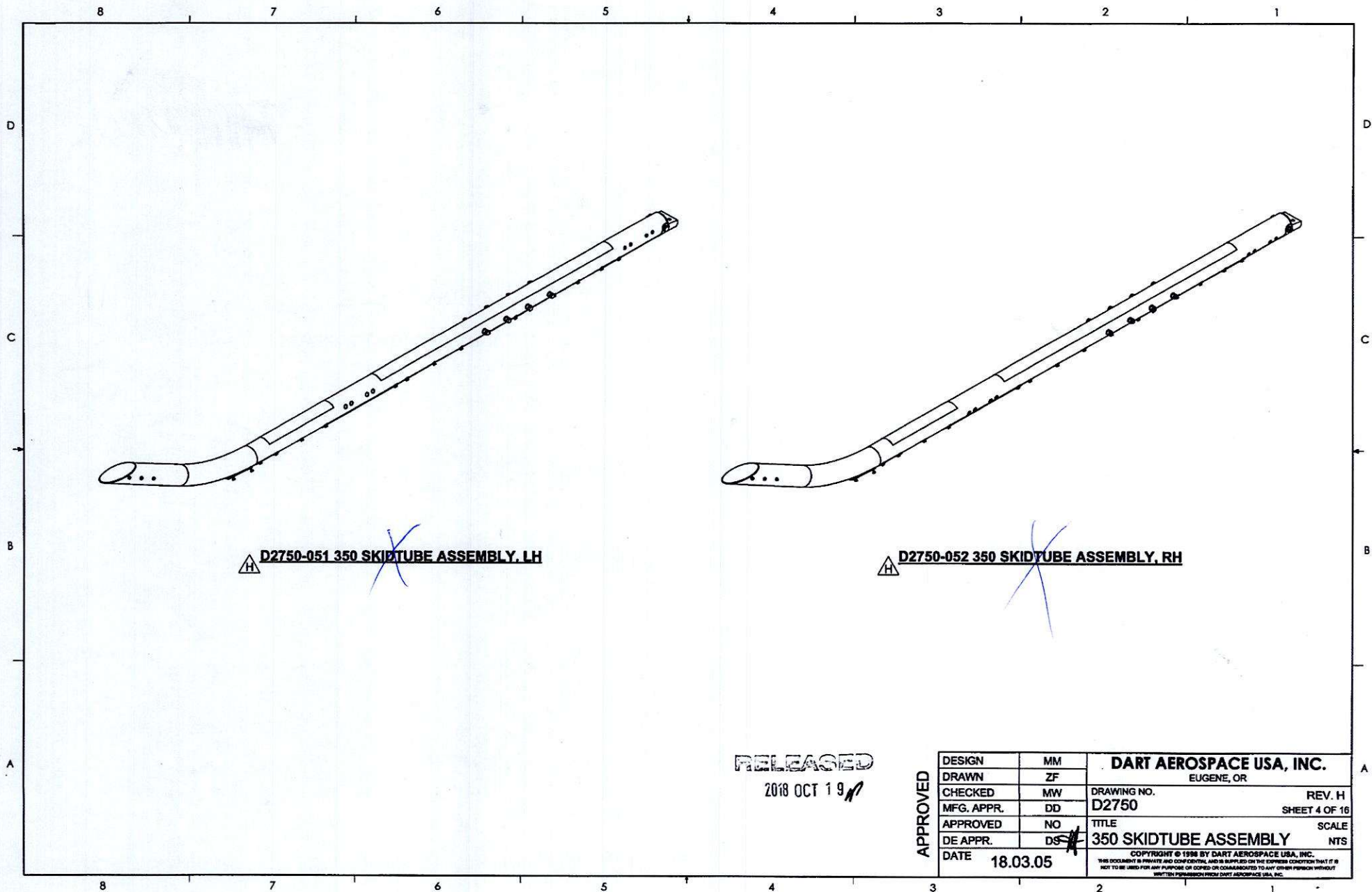
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



~~D2750-044 350 SKIDTUBE ASSEMBLY, RH~~

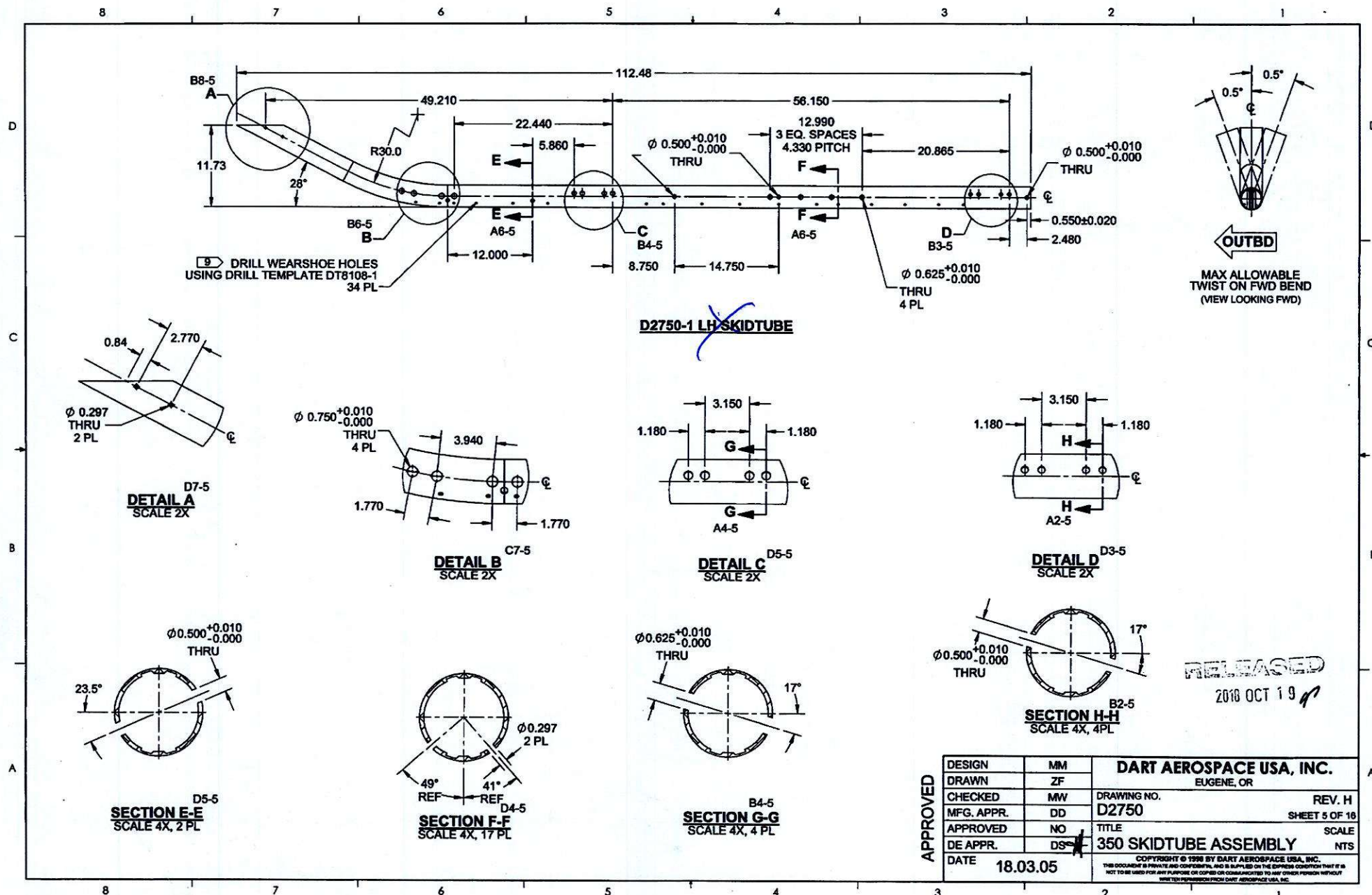




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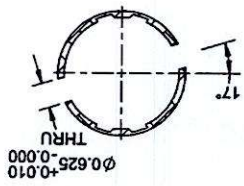
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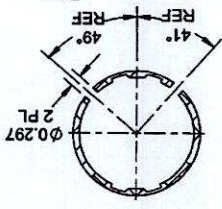
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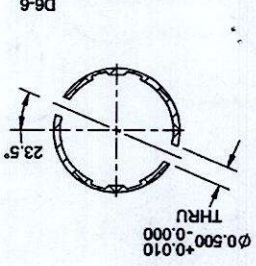
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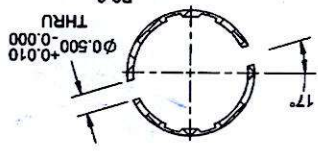
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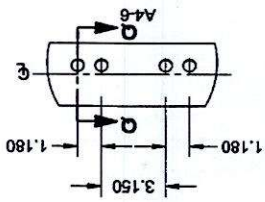
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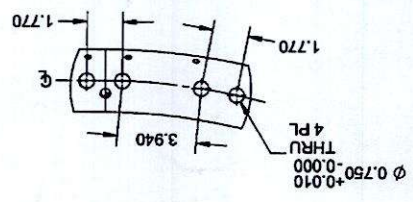
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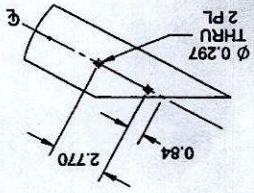
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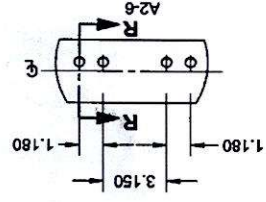
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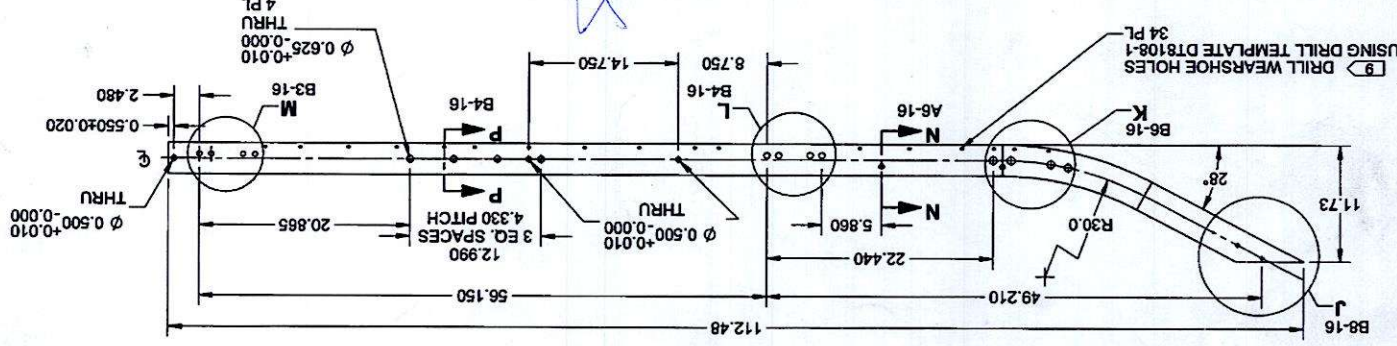
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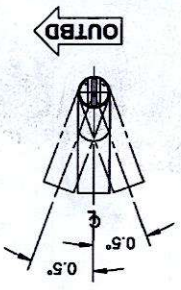
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D2750-2 RH SKIDTUBE

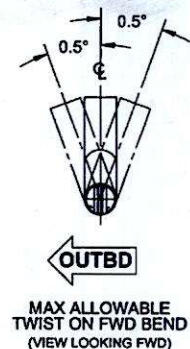


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)

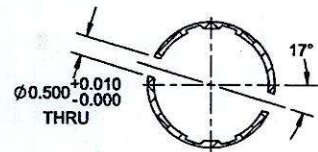
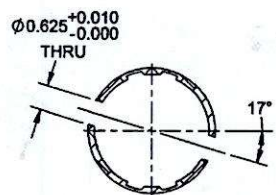
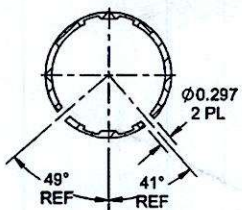
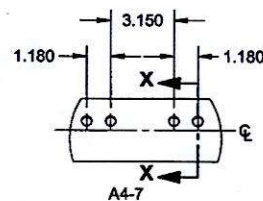
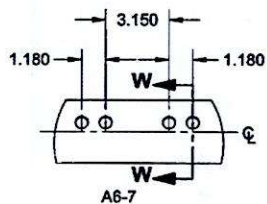
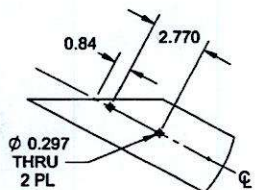


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9 DRILL WEARSHOE HOLES
USING DRILL TEMPLATE DT8108-1
34 PL



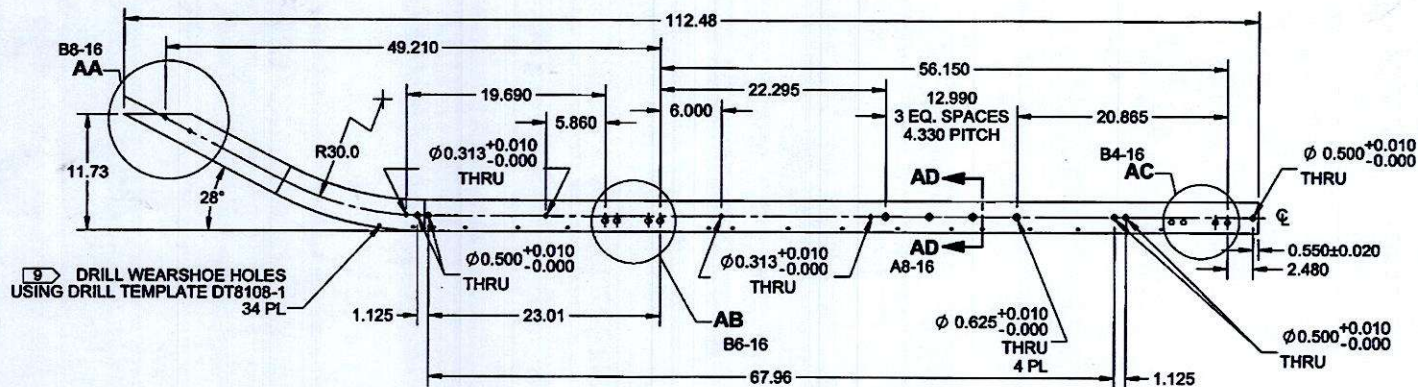
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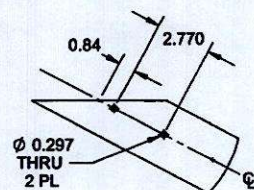
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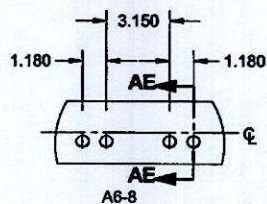
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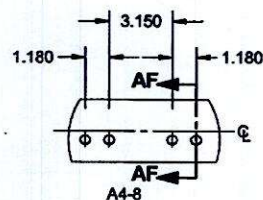
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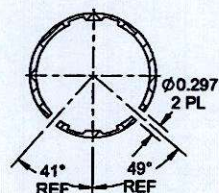
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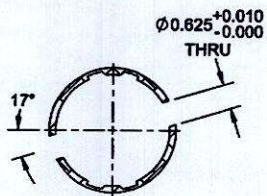
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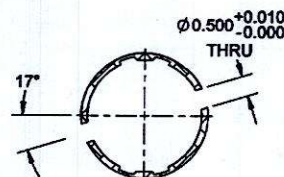
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SECTION AD-AD
SCALE 4X, 17 PL



SECTION AE-AE
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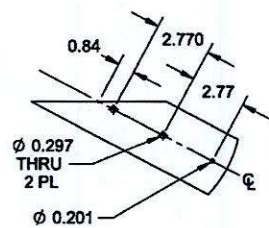
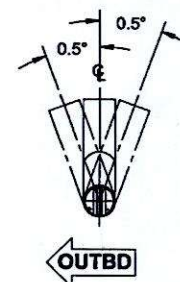
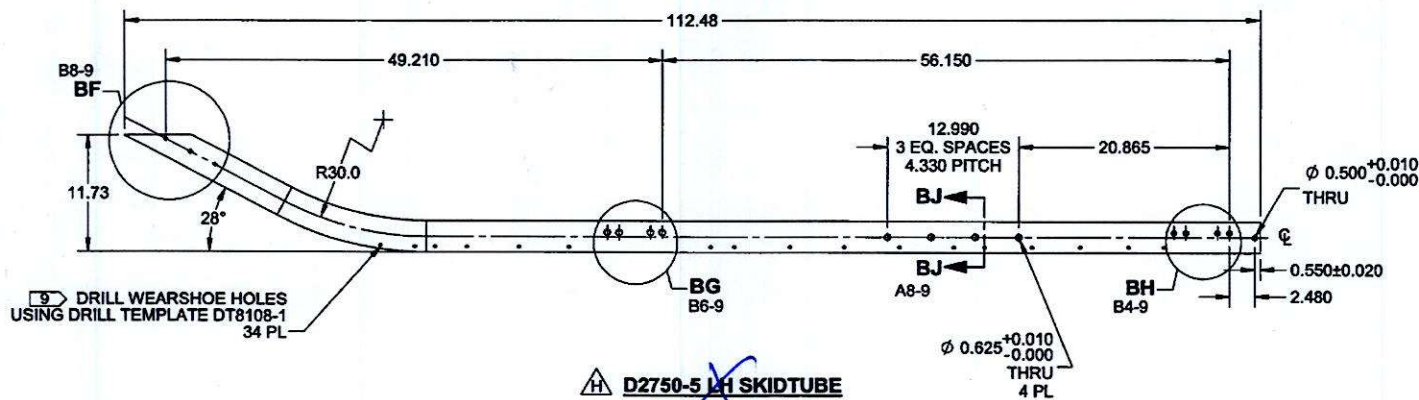


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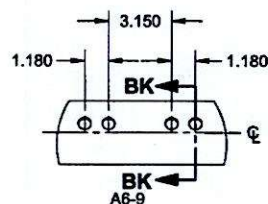
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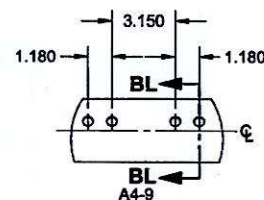
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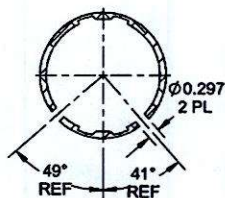
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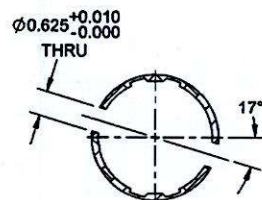
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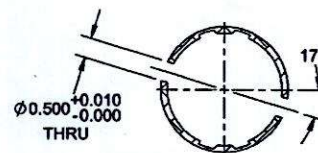
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D4-9
SECTION BJ-BJ
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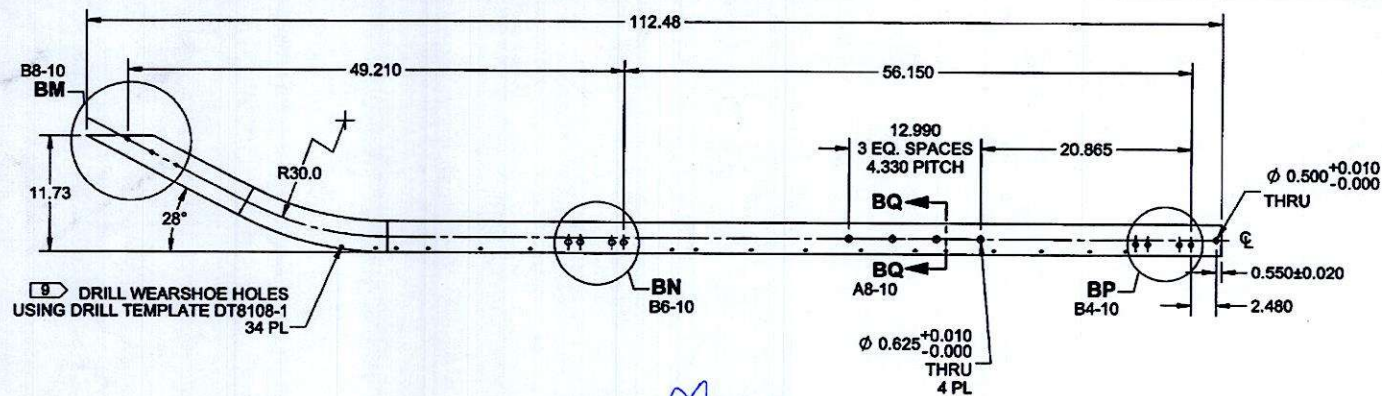
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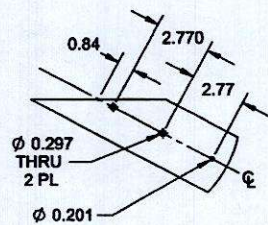
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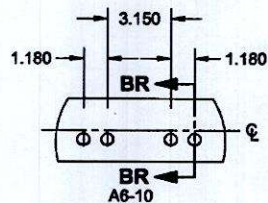
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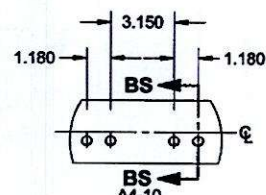
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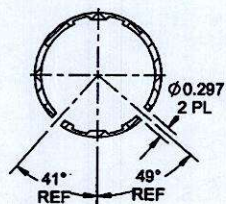
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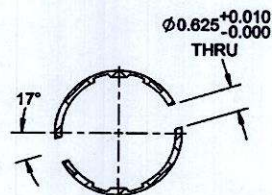
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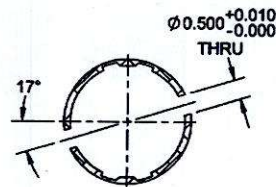
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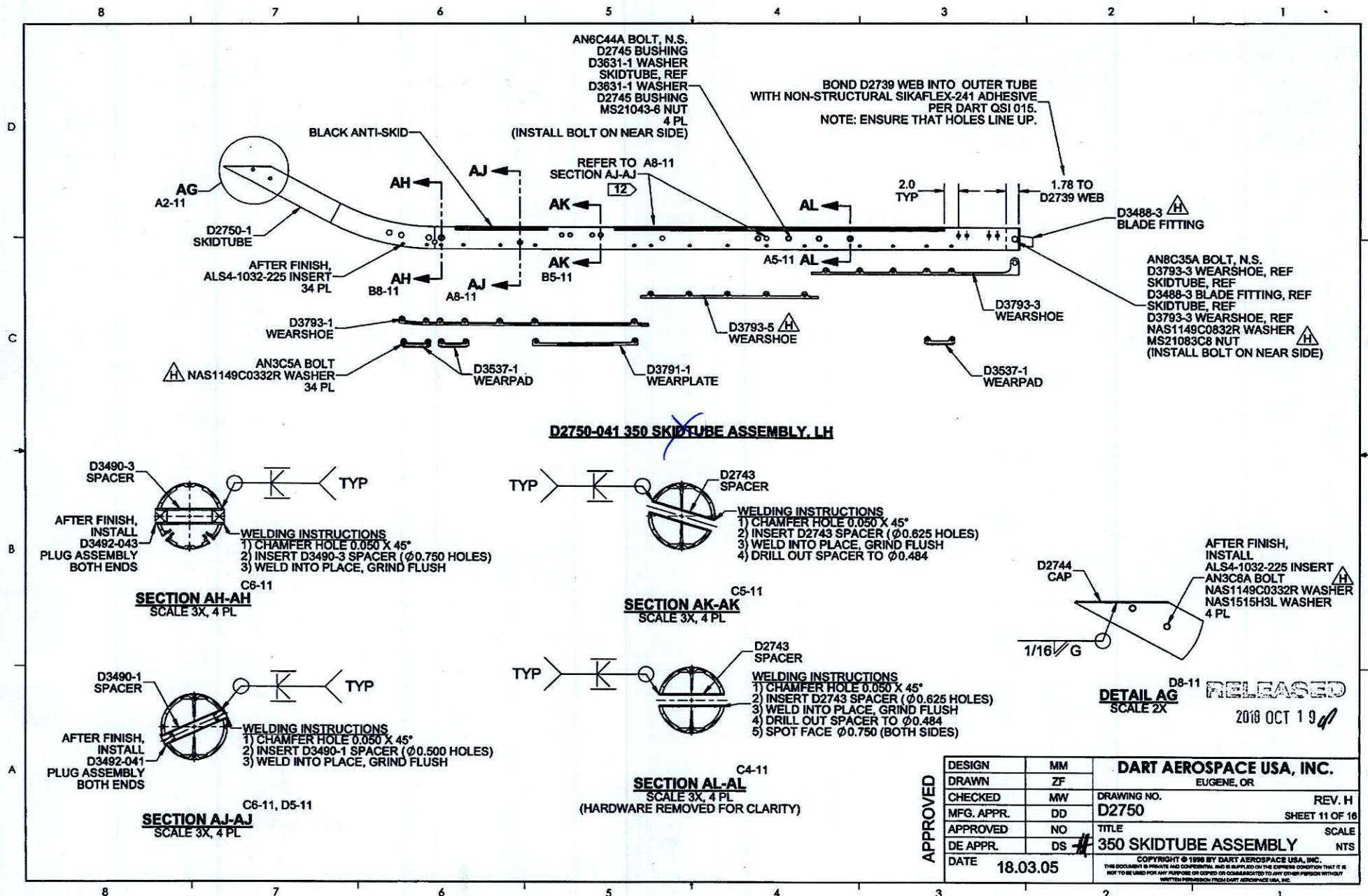


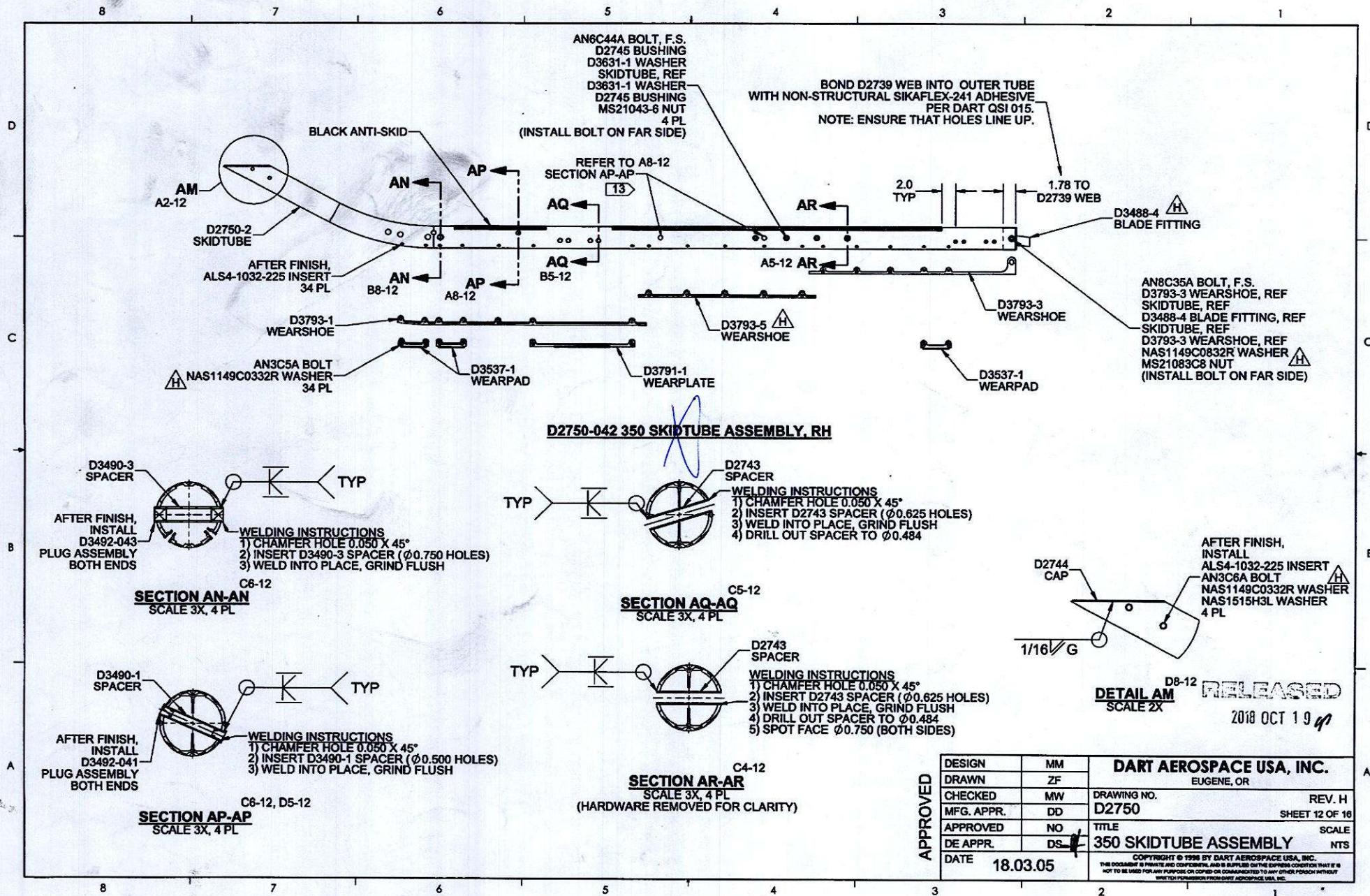
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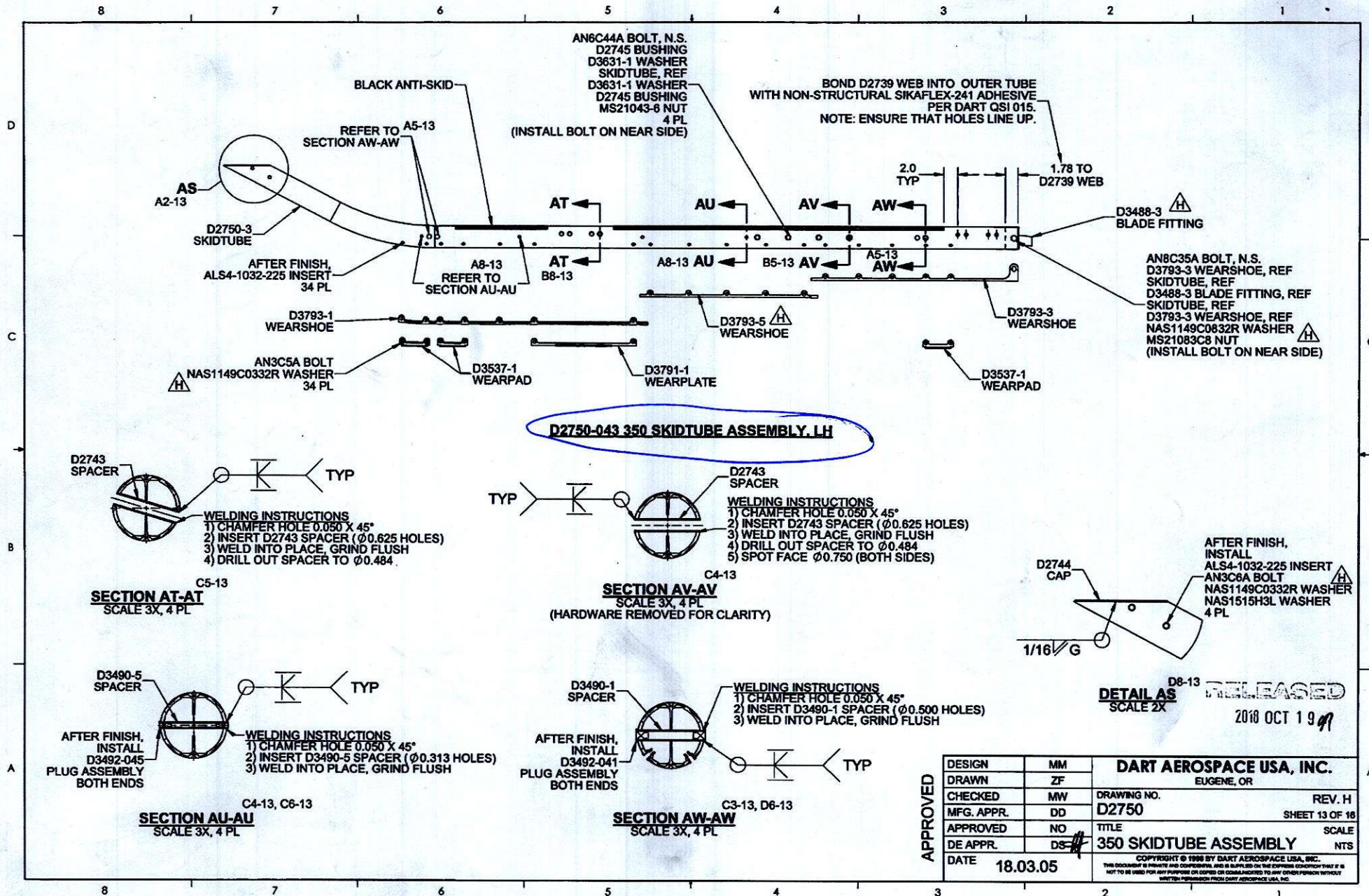
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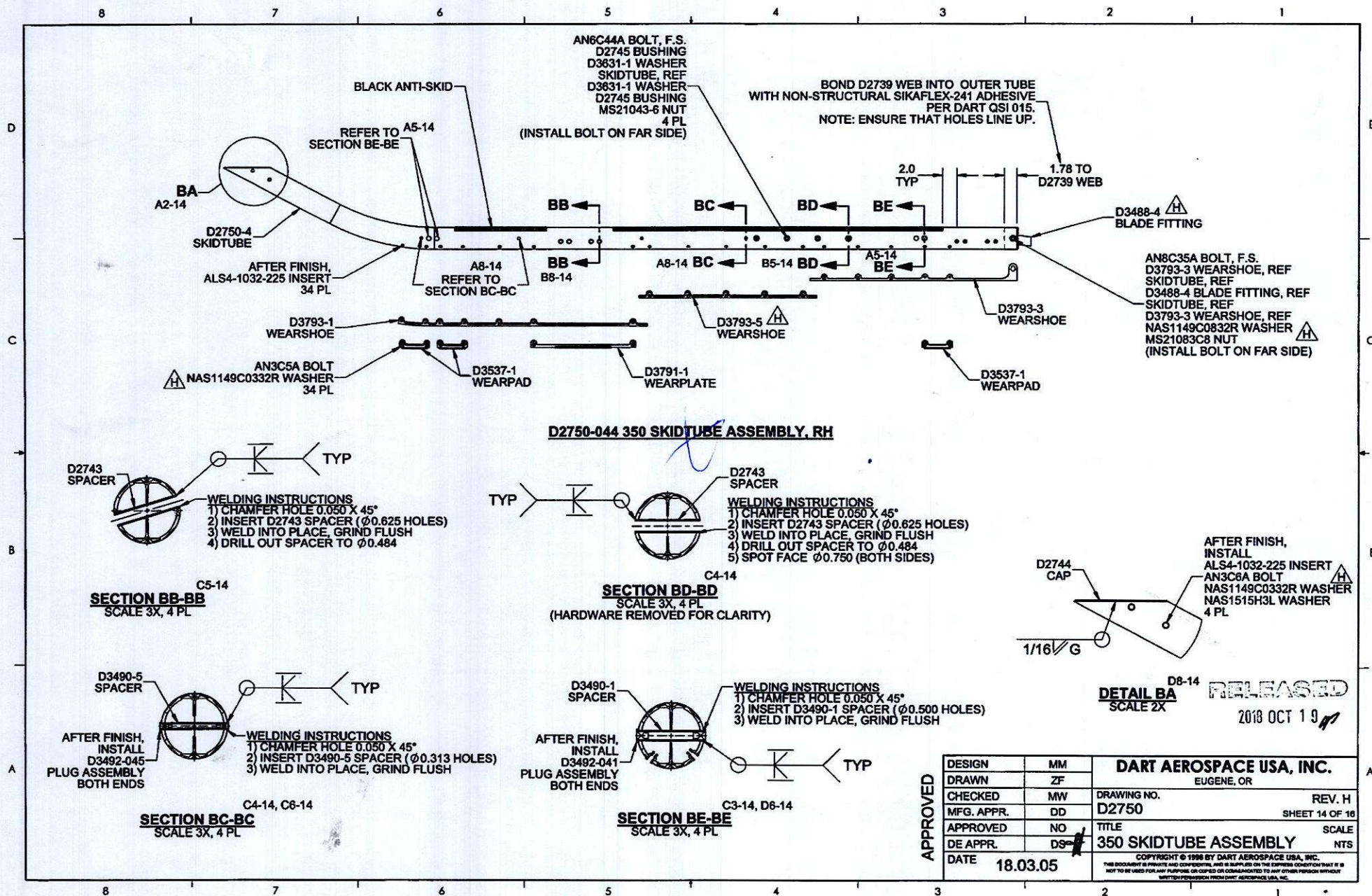
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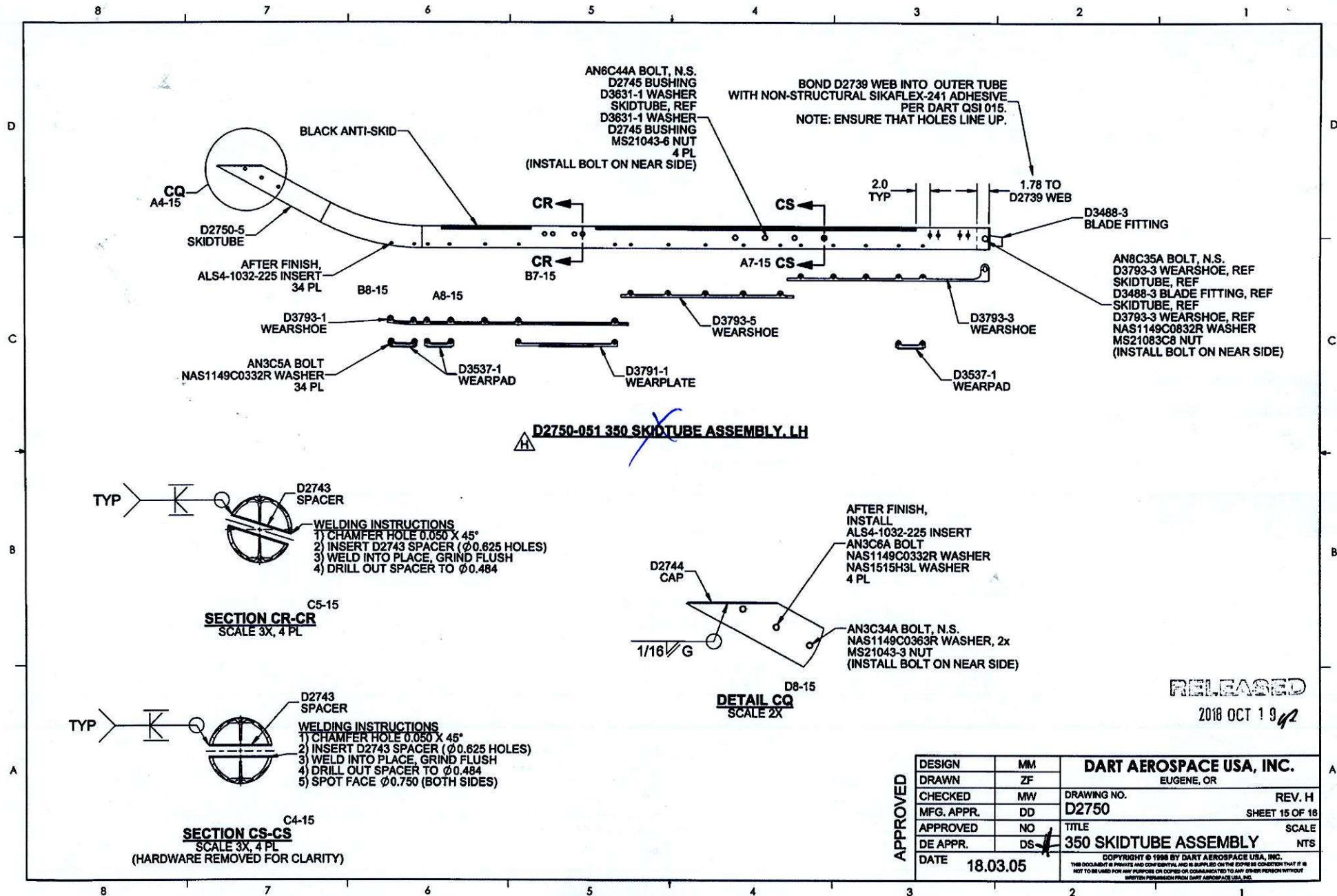






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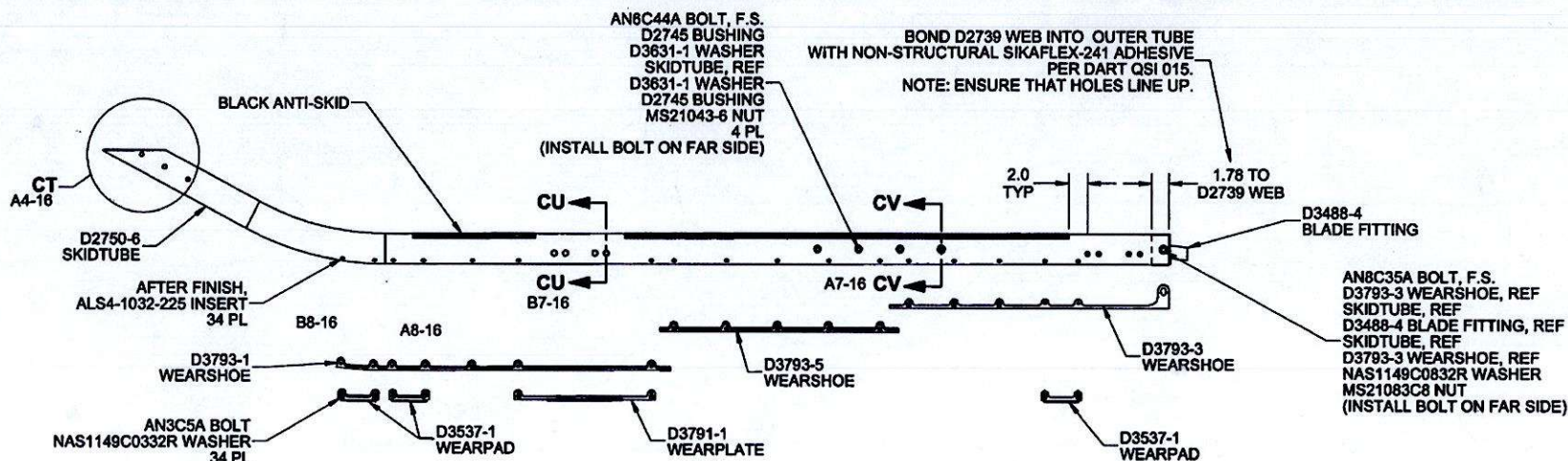




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2018 OCT 19

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	DRAWN	ZF	EUGENE, OR	
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 15 OF 18
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	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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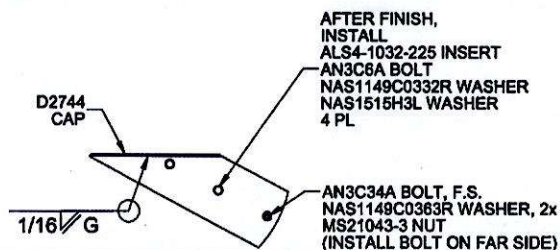
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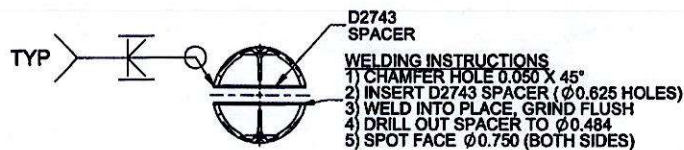
D2750-052 350 SKIDTUBE ASSEMBLY, RH



SECTION CU-CU SCALE 3X, 4 PL



DETAIL CT SCALE 2X



SECTION CV-CV SCALE 3X, 4 PL

(HARDWARE REMOVED FOR CLARITY)

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2018 OCT 19

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	MFG. APPR.	DD	D2750	SHEET 16 OF 16
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	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Hawkesbury, ON K6A 1K7
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TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S235217



Part: D350-636-013

Job No: 203446

Serial No/Batch: S235217

Revision: H

Inspector:

Exp Date:

Instructions: FAA STC SR00646SE 18/10/17, TC, STC SH99 -

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
*22A	1	1	1	1	1	1	1	D3791-1	WEARPLATE
*23A	1	1	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*24A	1	1	1	1	1	1	1	D3793-5	WEARSHOE (REPLACES D3535-25)
*25A	1	1	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*26A	34	34	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	34	34	NAS1149C0332R	WASHER
*28	34	34	34	34	34	34	34	ALS4-1032-225	INSERT
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
50	2	2						D3532-1	SPACER
****97					1	1		AN3C34A	BOLT
****98					2	2		NAS1149C0363R	WASHER
****99					1	1		MS21043-3	NUT
100A							4	AN526C1032R10	SCREW
100B							4	AN526C1032R18	SCREW

- * PART OF D2750-041/-042, D2750-043/-044 OR D2750-051/-052 ASSEMBLY
- ** TO BE SUPPLIED BY CUSTOMER
- *** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM
- **** PART OF D2750-051 OR D2750-052 ASSEMBLY

5.0 PARTS LIST

D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 008 AND SUBSEQUENT
D350-636-021/-022 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
	X							D350-636-011	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
		X						D350-636-012	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
			X					D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
				X				D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
					X			D350-636-021	SKIDTUBE INSTALLATION, LH, STD
						X		D350-636-022	SKIDTUBE INSTALLATION, RH, STD
							X	D350-636-049	WEARSHOE KIT
1	1							D2750-041	SKIDTUBE ASSEMBLY, LH
1		1						D2750-042	SKIDTUBE ASSEMBLY, RH
1			1					D2750-043	SKIDTUBE ASSEMBLY, LH
1				1				D2750-044	SKIDTUBE ASSEMBLY, RH
1					1			D2750-051	SKIDTUBE ASSEMBLY, LH
1						1		D2750-052	SKIDTUBE ASSEMBLY, RH
*1	1							D2750-1	SKIDTUBE WELDMENT, LH
*1		1						D2750-2	SKIDTUBE WELDMENT, RH
*1			1					D2750-3	SKIDTUBE WELDMENT, LH
*1				1				D2750-4	SKIDTUBE WELDMENT, RH
1					1			D2750-5	SKIDTUBE WELDMENT, LH
1						1		D2750-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149C0832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
8	1		1		1			D3488-3	BLADE FITTING, LH
8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149DO863J	WASHER
11C							8	D3672-1	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149C0332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER
*22	3	3	3	3	3	3	3	D3537-1	WEARPAD

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Revision: K

Date: 18.04.04